

INCH-POUND

A-A-55284

September 26, 1995

COMMERCIAL ITEM DESCRIPTION

BUCKLES, BRASS

The General Services Administration has authorized the use of this commercial item description as a replacement for MIL-B-17910D and MIL-B-20588F for all Federal agencies.

1. SCOPE. This commercial item description covers buckles intended for use with the men's coat belt or the military police belt.

2. CLASSIFICATION. The buckles shall be of the following classes and types:

Class 1 - Solid polished brass (Marine Corps)

Type I - Red brass

Type II - Yellow brass

Class 2 - Die cast zinc and aluminum alloy with chrome-plated finish

Class 3 - Die cast zinc and aluminum alloy with brass-plated finish

Beneficial comments, recommendations, additions, deletions, clarifications, etc. and any data which may improve this document should be sent to: Defense Personnel Support Center, Clothing and Textiles Directorate, Attn: DPSC-FQSE, 2800 South 20th Street, Philadelphia, PA 19145-5099.

AMSC N/A

FSC 8315

DISTRIBUTION STATEMENT A.

Approved for public release;
distribution is unlimited.

3. SALIENT CHARACTERISTICS. The class 1, type I buckle shall be 1-3/16 x 2-5/32 x 3/32 inch ($\pm 1/64$ inch), and the corners and edges shall be slightly beveled. The thickness of the outside vertical portions of the body shall be .250 ($\pm .005$) inch. The thickness of the outside horizontal portions of the body shall be .156 ($\pm .005$) inch. The thickness of the inside vertical bar shall be .187 ($\pm .005$) inch. The class 1, type II buckle shall have outside dimensions of 2 x 2-5/16 x 1/8 inch ($\pm 1/16$ inch) and shall be of stamped construction. The inside dimensions of the buckle shall be 1-1/2 x 1-13/16 x 1/8 inch ($\pm 1/16$ inch). The center vertical bar shall be 1/4 inch thick, and the tongue wire shall be .144 ($\pm .005$) inch in diameter. The class 2 and class 3 buckles shall have outside dimensions of 2-3/8 x 2-7/16 x 3/16 inch ($\pm 1/16$ inch) and shall be of die cast construction. The inside dimensions of the buckle shall be 1-3/4 x 1-13/16 x 3/16 inch ($\pm 1/16$ inch). The center vertical bar shall be 7/32 inch thick, and the tongue wire shall be .144 ($\pm .005$) inch in diameter. Figures 1 and 2 are furnished for informational purposes only.

3.1 Materials

3.1.1 Class 1, type I and type II. The body of the type I buckle, made from copper alloy number 230 (red brass), and the type II buckle, made from copper alloy number 260 or 268 (yellow brass), shall conform to ASTM B36 or ASTM B121 requirements. A cut-out shall be provided in the center bar of the type II buckle to retain the tongue in position in the center of the bar. The top surfaces and outside edges of the buckle body shall be polished to a uniform, mirror-like finish. The back shall have a satin finish.

3.1.2 Class 2 and class 3. The body of the class 2 and class 3 buckles shall be die cast from a zinc base alloy conforming to ASTM B86 requirements. Ribs shall be provided on the center bar to retain the tongue in the center of the bar. All surfaces of the class 2 buckle body shall be burnished to a smooth surface texture. The body shall then be copper plated followed by nickle plating and then by chrome plating. The top surfaces of the buckle body which are exposed to view when worn shall be polished to a uniform, mirror-like finish. The class 3 buckle body shall be prepared and plated in the same manner as the class 2 buckle; except, in lieu of chrome, the final plating shall be brass. After polishing, the body shall be coated with a clear, baked-on epoxy lacquer.

3.1.3 The tongue. The wire for the tongue (except class 1, type I) shall be fabricated from copper alloy number 260 and 270 conforming to ASTM B134, ASTM B159, or ASTM B206 requirements. When assembled to the buckle body, the tongue shall not bind on the center bar; the tip of the tongue shall not protrude beyond the outer edge of the body, but shall protrude a minimum of 3/64 inch beyond the inner edge of the body; it shall not be possible by hand to slide the tongue out of the cutout in the center bar

of the class 1 body (type II only) or over the ribs in the center bar of the class 2 and class 3 body; and the total lateral movement of the tongue tip shall not exceed 5/8 inch. The tongue for the class 1, type II buckle shall be brass dipped. The tongue for the class 2 buckle shall be nickel-plated, followed by a lacquer coating. The tongue for the class 3 buckle shall be coated with a clear, baked-on epoxy lacquer.

3.2 Label/markings. All buckles shall be marked for identification with the manufacturer's name or trademark. The marking shall be permanently affixed by stamping, etching, or casting on the back of the buckle and shall be legible.

4. REGULATORY REQUIREMENTS. The offeror/contractor is encouraged to use recovered materials to the maximum extent practicable, in accordance with paragraph 23.403 of the Federal Acquisition Regulation (FAR).

5. QUALITY ASSURANCE PROVISIONS

5.1 Certification. The contractor shall certify and maintain substantiating evidence that the product offered meets the salient characteristics of this commercial item description; conforms to the producer's own drawings, specifications, standards, and quality assurance practices; and is the same product offered for sale in the commercial marketplace. The Government reserves the right to require proof of such conformance prior to the first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

5.2 Market acceptability criteria. The item offered, or a generic equivalent, must have been sold to the commercial market or to the Government for at least two years.

5.3 Warranty. The item offered shall include the standard warranty given to the commercial market beginning with the date of delivery of the individual items.

5.4 Visual examination. Each buckle shall be examined for the defects listed below.

5.4.1 Defects. Not finished or type of finish not as specified; noticeable discoloration, corrosion, or stain; foreign matter embedded in finish of surfaces which are exposed to view when in use; surfaces exposed to view are abraded, scuffed, scratched, or not smooth; lacquered coating (where applicable) blushed, cloudy or not clear, not adherent, blistered, flaking or peeling, not continuous or level; coating not level, uniform, and continuous, e.g., runs, orange peel, wrinkles, drops, or streaks; plating (where applicable) is broken, cut through, corroded, or erupted; class 2 not chrome plated or plating has frosty area on surfaces exposed to view; distorted, bent, malformed, cracked, drag or step in construction and workmanship; digs, gauges, burrs, nicks;

tongue fractured, malformed, bent or damaged, binds on center bar; tongue loop loose or open to an extent such that the tongue can be dislodged manually from its position on the center bar; marking missing, illegible, or not as specified; any items not packaged in accordance with the contract or purchase order.

5.5 Bid samples. Sample buckles shall be submitted for bid sample testing. Finished buckles shall match an approved sample for acceptability of color and finish.

6. PACKAGING

6.1 Preservation, packing, and marking. The preservation, packing, and marking shall be as specified in the contract or order.

7. NOTES

7.1 Source of Government documents. Copies of military and Federal documents are available from:

Standardization Documents Order Desk
Bldg. 4D
700 Robbins Avenue
Philadelphia, PA 19111-5094

7.2 Source of non-Government documents

ASTM Test Methods

(Applications for copies should be addressed to American Society For Testing and Materials, 1916 Race Street, Philadelphia, PA 19103-1187.)

7.3 Acceptance criteria. Acceptance criteria shall be as specified in the contract or purchase order.

MILITARY INTERESTS:

Custodians

Army - GL
Navy - MC

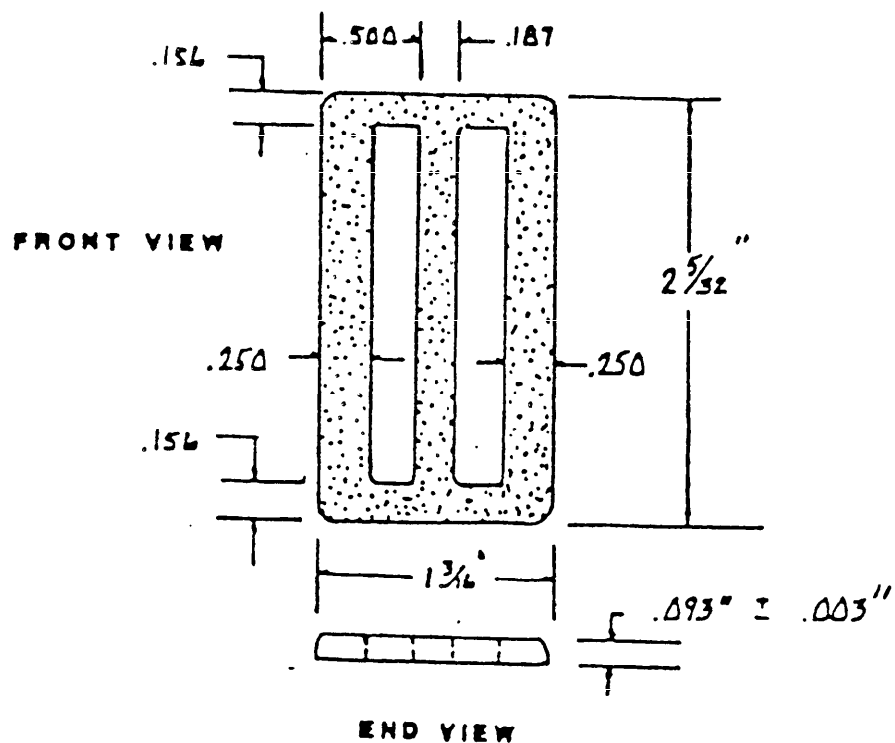
Review Activities

Army - MD

CIVIL AGENCY COORDINATING
ACTIVITY:
GSA - FSS

PREPARING ACTIVITY:
DLA - CT

Project 8315-0390



TOLERANCES:

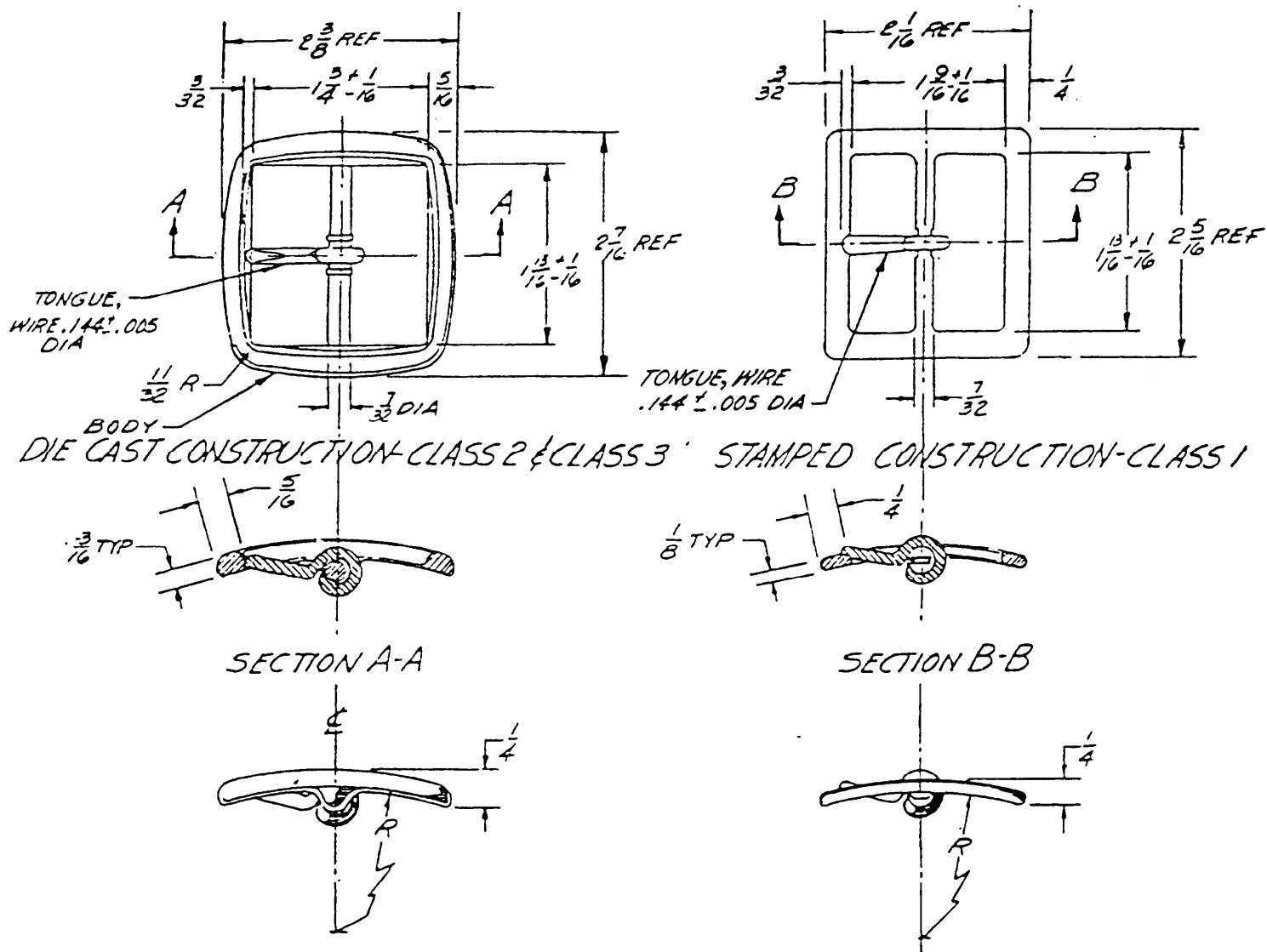
FRACTIONS $\pm \frac{1}{64}$ "

DECIMALS $\pm .005$ "

NOTE: ALL CORNERS AND EDGES SHALL BE SLIGHTLY BEVELED

BUCKLES, BRASS (Class 1, Type I)

FIGURE 1.



BUCKLES, BRASS: Class 1 (Type 1), Class 2 & Class 3

FIGURE 2.